

Date: Monday, 11/08/2008 2:45:28 PM  
 User: Linda Lacelle,

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARSHOE		
Job Number	: 41125					
Estimate Number	: 10613					
P.O. Number	:			Part Number	: D265615	
This Issue	: 11/08/2008		S.O. No. :	Drawing Number	: D2656 REV D	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	Purchasing Revision	: D	
Previous Run	: 34596			Material	:	
Written By	:			Due Date	: 20/08/2008	
Checked & Approved By	: <u>JUL 08 8.11</u>			Qty:	20 Um: Each	
Comment	: Est: D 02.10.25 Re-format KJ Est Rev:E Now on Waterjet 06-09-25 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M1010S20GA	1010/1025 SHEET	
		Comment: Qty.: 0.6431 sf(s)/Unit Total : 12.8625 sf(s) 1010/1025/A21/6aA SHEET (.040") (M1010S20GA) Batch: <u>108275</u> HB 8-8-19	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2656 Dwg Rev: <u>B</u> HB 8-8-19 Prog Rev: <u></u>	
		2-Deburr if necessary HB 8-8-19	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>HB 8-8-19</u>	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK <u>S 08/08/15 X26</u> counted	
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE 1-Form on Brake as per Dwg D2656 using Jigs DT8261and DT8326 2-Form joggle as per Dwg D2656 using Jig DT8158 3-Identify as D2656-15	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/08/2008 2:45:28 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 41125

Part Number: D265615

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



centered

08/08/28

426

Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



M106442



26x

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

8-20

OVEN TEMPERATURE:

320°

FINISH TIME:

8-50

m-f

08/08/29

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



23

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



26

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-20

FL 08/08/29

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/02 FL

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 0808-29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41125
Description: Wearshoe	Part Number:	D2656-15
Inspection Dwg: D2656	Rev: D	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

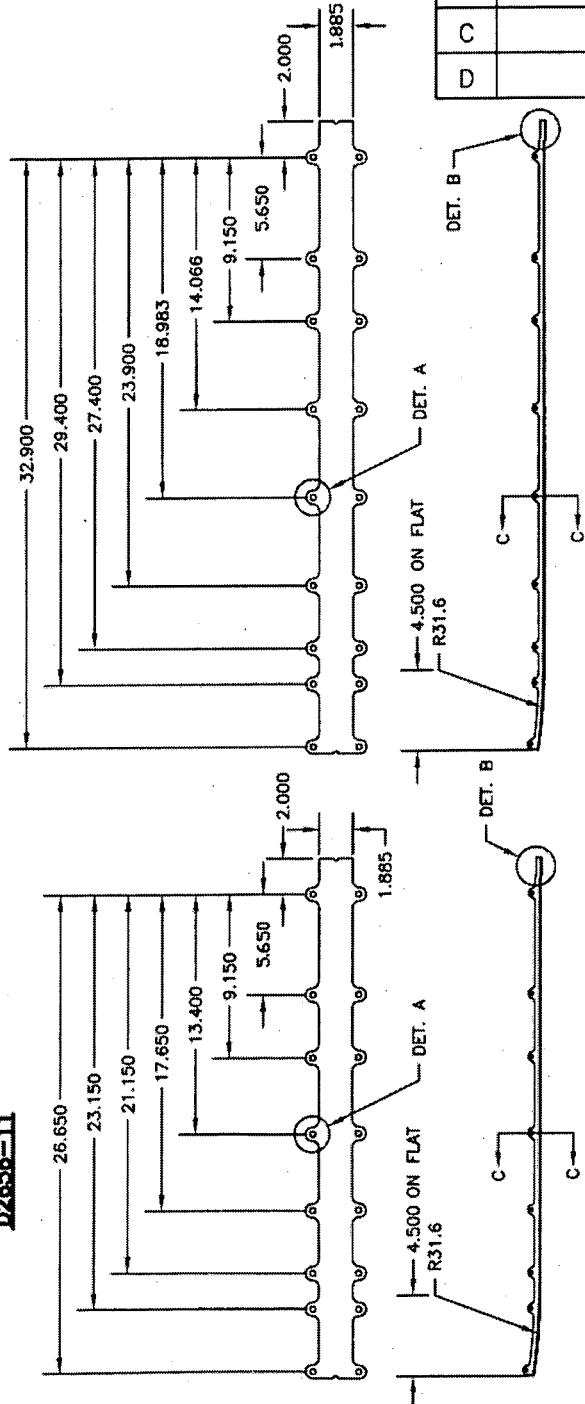
Measured by:	BS	Audited by:	✓	Prototype Approval:	N/A
Date:	8-8-19	Date:	08/08/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	E



DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DS	CP	
CHECKED	APPROVED	DRAWING NO. D2656 REV. D SHEET 1 OF 4
DATE	TITLE WEARSHOE	
05.08.17	SCALE 1:10	
A	97:03:25	NEW ISSUE
B	97:06:02	CHANGED TABS
C	97:06:26	R31.6 WAS R19.5
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT

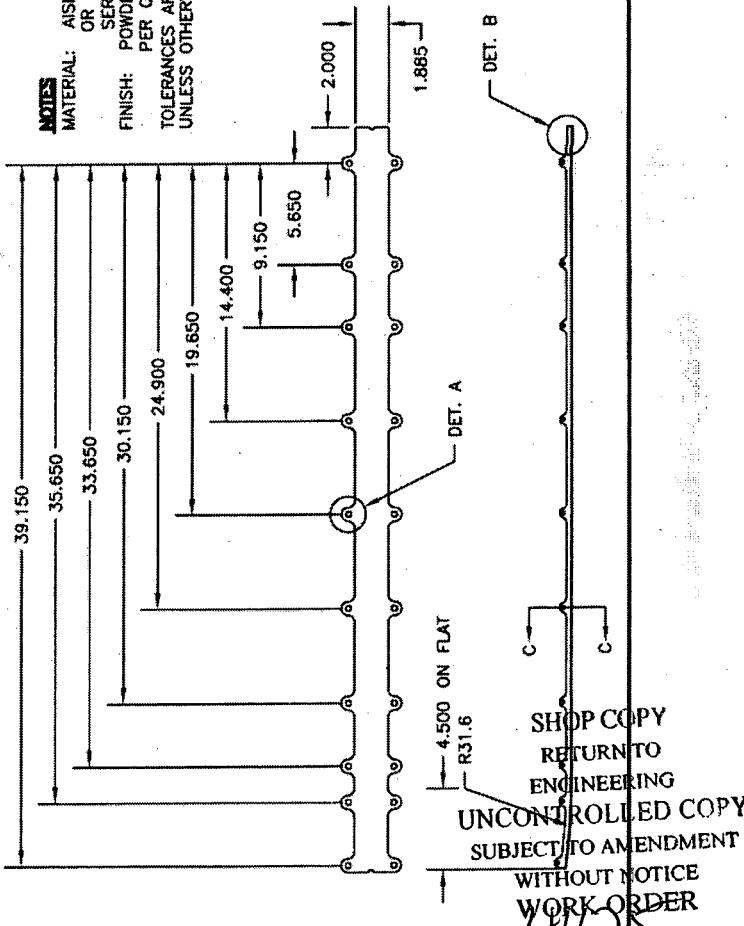
D2656-13



D2656-11

**NOTES**  
MATERIAL: AISI 1010-1025 OR ASTM A36/A1068  
OR CSA G40-21, 38W/4.4W/50W/60W/70W  
SERIES STEEL, 20 GAUZE (0.040 THICK)  
FINISH: POWDER COAT GREY SANTEX (4.3.5.6)  
PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

D2656-15



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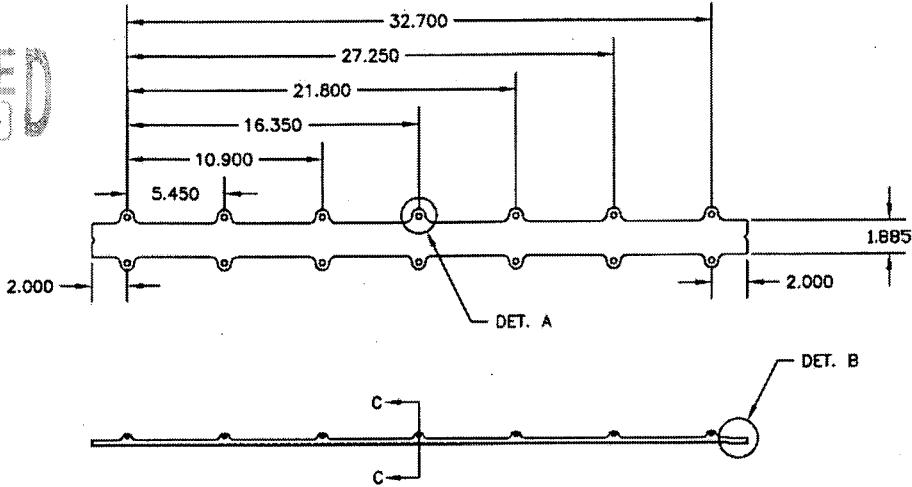
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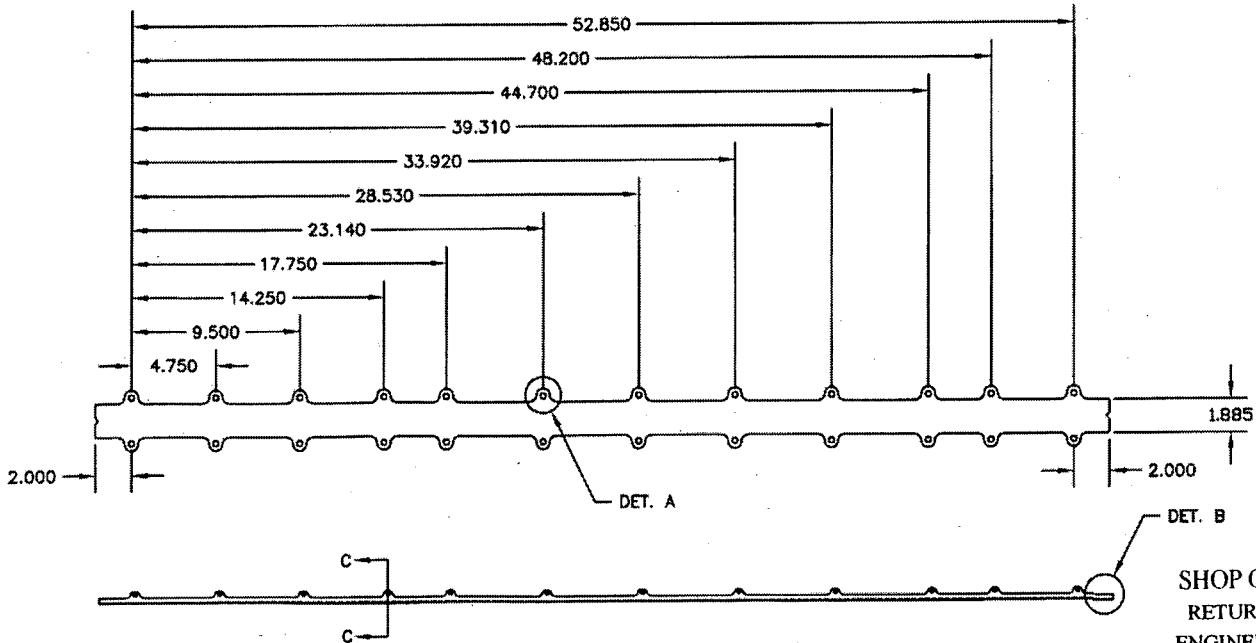
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DATE 05.08.17		REV. D SHEET 2 OF 4 TITLE WEARSHOE SCALE 1:10

D2656-21

RELEASED  
05.07.06 *[Signature]*



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)

FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

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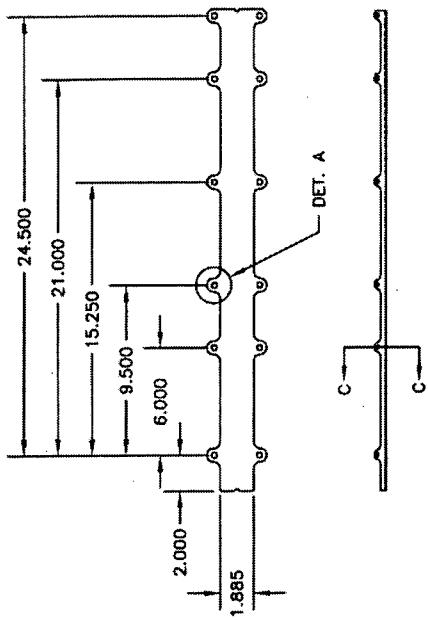
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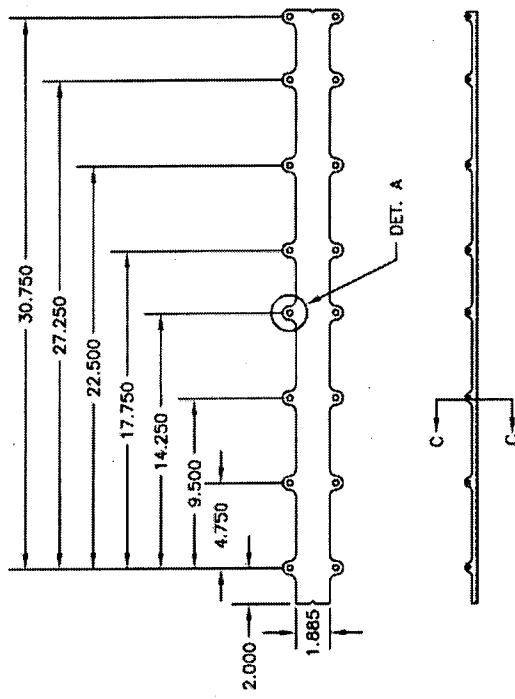


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05.08.17		TITLE WEARSHOE SCALE 1:10

D2656-31

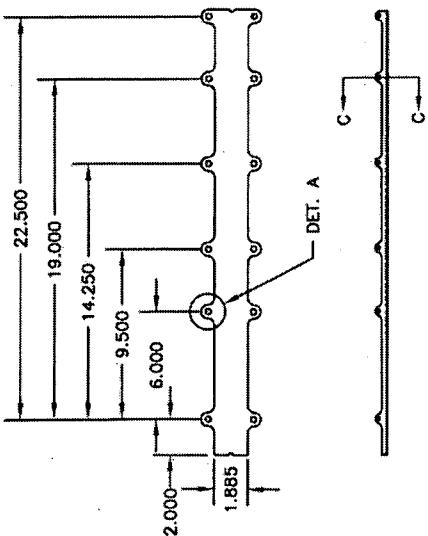


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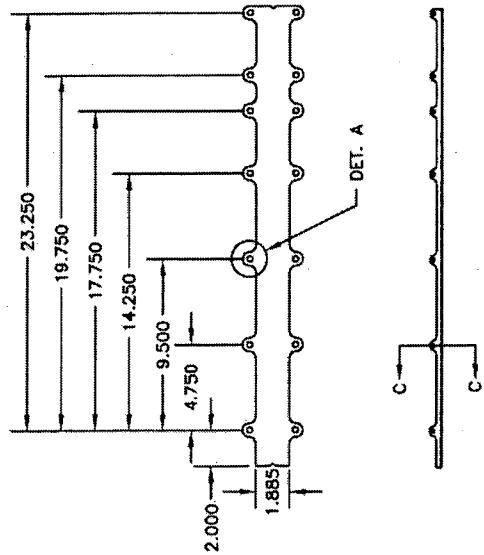


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05.09.06

D2656-31



D2656-35



NOTES:  
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
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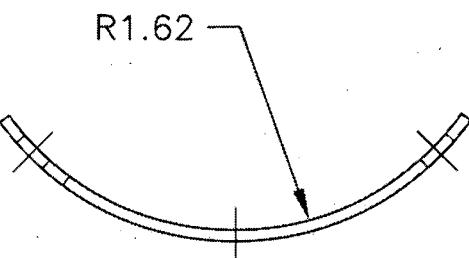
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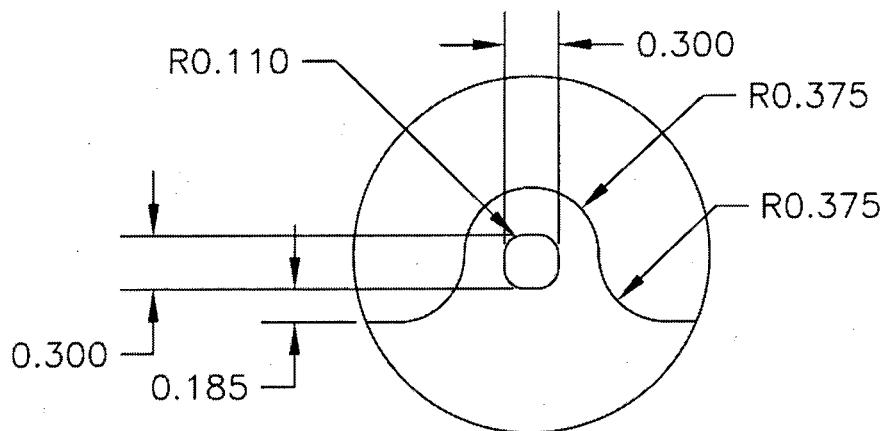
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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

### SECTION C-C

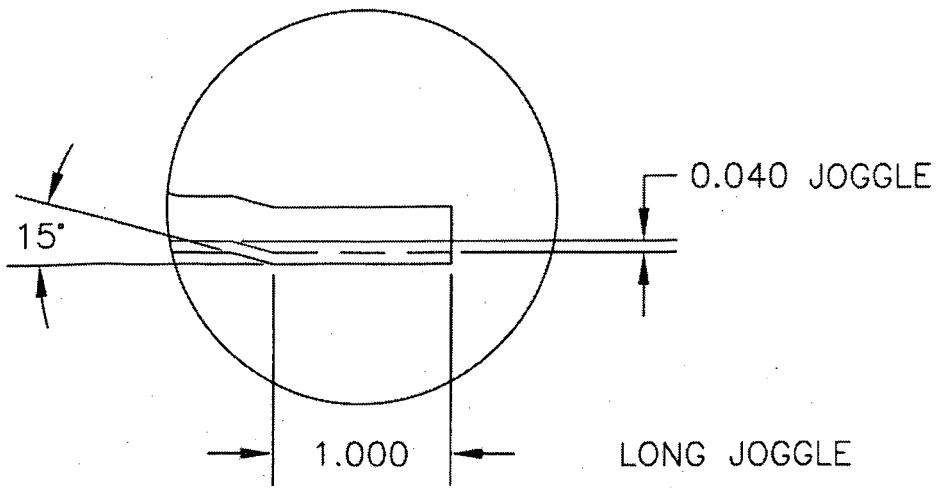


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### DETAIL A



### DETAIL B



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